

Date: Thursday, 12/13/2007 2:39:01 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PLUG
Job Number : 36327	
Estimate Number : 10178	
P.O. Number : <i>N/A</i>	Part Number : D25941
This Issue : 12/13/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2594 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 35919	Material : <i>N/A</i>
Written By : <i>HA</i>	Due Date : 1/24/2008 Qty: 500 Um: Each
Checked & Approved By : <i>HA 07.12.13</i>	
Comment : Est D 02.08.22 Make in Cobra KJ	
est E 06.12.11 ecn 836 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6R0625	6061-T6 Round Bar .625"
-----	--------------	-------------------------



Comment: Qty.: 0.0547 f(s)/Unit Total : 27.3525 f(s)
 Material: 5052-H32 (QQ-A-225/7) or 6061-T6 (QQ-A-225/8)
 1100-0 (QQ-A-225/1) Ø0.625" Rod
 (M5052H32R0.625) or (M6061T6R0.625). Batch *M106104* *H.A 07/12/19*

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



Comment: HARDINGE CNC LATHE SMALL
 1-Make as per Dwg D2594-1 and Folio FA262.
 2-Break all sharp edges 0.010 max.

H.A/mk 07/12/19
RP 07/12/19

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

RP 07/12/21

07/12/19

542 *598*

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

56 07.12.22

542

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1
 Acid etch and alodine as per QSI 005 4.1

BR 08-01-04

542

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 08/01/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/13/2007 2:39:01 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 36327

Part Number: D25941

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M 106379



(542)

Comment: POWDER COATING

Powder Coat Gloss White (Ref: 4.3.5.1) per Dart QSI 005 4.3 (only larger dia. section necessary)

BR 0801-07.

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



M-1 08/01/08
~~*M 106379*~~



(542X)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

~~*BR 0801-07.*~~

8.0

PACKAGING 1

PACKAGING RESOURCE #1



(542X)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *F.P-I*

M-1 08/01/08

9.0

QC21

FINAL INSPECTION/W/O RELEASE



(542)

Comment: FINAL INSPECTION/W/O RELEASE

08/01/08

Job Completion



2008.1.18

h

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

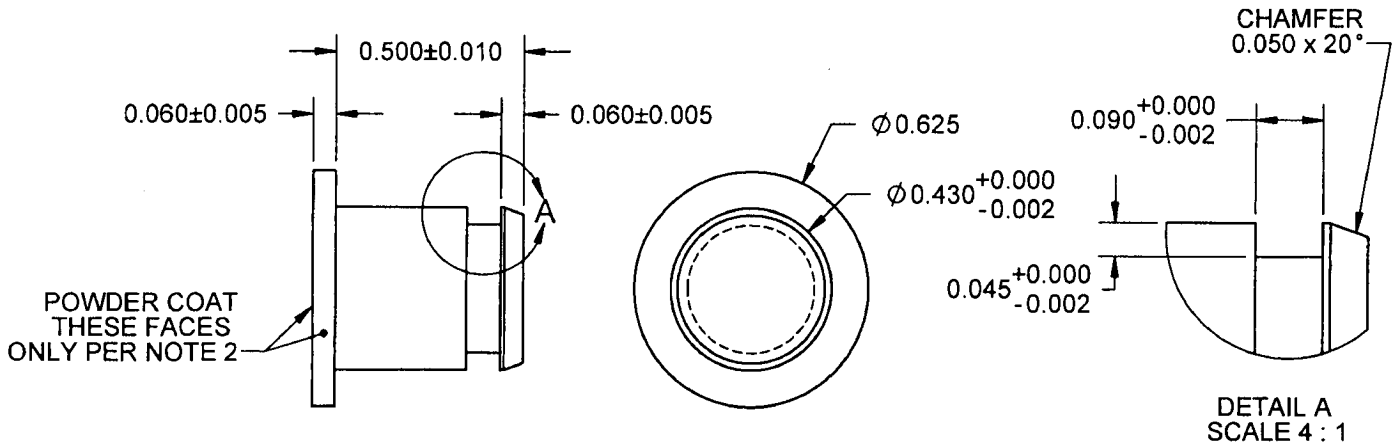
NOTE: Date & initial all entries

DART

DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D2594	REV. C SHEET 1 OF 1
DATE 06.11.20	TITLE PLUG		SCALE 2:1
REV	DATE	DESCRIPTION	
A	96.09.16	NEW ISSUE	
B	97.03.15	ADD GROOVE AND O-RING	
C	06.11.20	ADD PWDR COAT; ADD MS P/N TO D2594-3; ADD AMS SPECS; ADD TOLERANCE NOTE	

RELEASED

06.11.28

**D2594-1 PLUG****D2594-1 PLUG NOTES:**

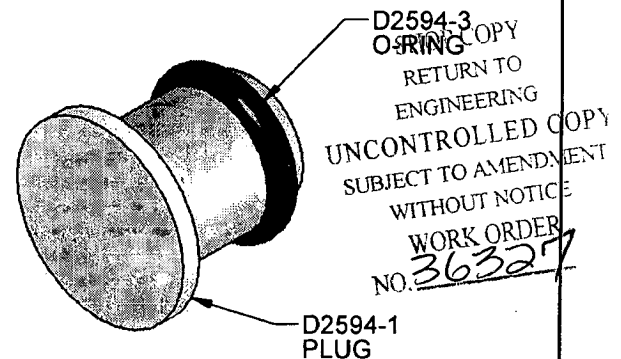
- 1) MATERIAL: ALUMINUM 5052-H32 ROUND BAR PER QQ-A-225/7 (REF DART SPEC M5052H32R) OR ALUMINUM 6061-T6/T651/T6510/T6511/T62 ROUND BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT SPECIFIED FACES WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3 \triangle
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

D2594-3 O-RING NOTES:

- 1) 5/16 ID, 7/16 OD, 1/16 WIDTH
- 2) POSSIBLE SUPPLIER P/N: PARKER 2-011 OR MS28775-011 \triangle

PARTS LIST:

QTY	P/N	DESCRIPTION
X	D2594	PLUG ASSEMBLY
1	D2594-1	PLUG
1	D2594-3	O-RING

**D2594 PLUG ASSEMBLY**

COPYRIGHT © 1996 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.